

Work Order ID 56347

Thursday, February 18, 2010 12:08:17 PM

Page 1

Item ID: D3267-041

Accept

Revision ID:

Item Name: Basket lid Assembly (Outside)

Start Date: 2/19/2010 Start Qty: 1.00

Required Date: 2/25/2010 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan: *mf*Date: *10-2-15*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3267

Rev C

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut Rib from 3/4" x 3/4" x 0.063" wall 304/316 SS tubing as per Dwg
D3267-2-Cut (4) D2236-1 From D3166-3-3-Drill holes in tubing D3267-041
as per Dwg D3267-4-Deburr & Remove All Markings From Material-5-Weld
D3267-041 Assembly using Welding Table and c

10.02.25

110

0.00



QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

Quality Control

10.02.25

120

0.00



QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

*8 10/2/25**(X)*

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Setup Start

Revision ID:

Stop

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

1ST COAT START TIME: 10:00 AM OVEN
TEMPERATURE: 16:30 FINISH TIME:
400°F ***** 2nd coat if
necessary ***** 2ND COAT: START TIME:
11:30 OVEN TEMPERATURE: 400°F

⇒ 10/02/03 (X1) Ø

140

HandFinishing

0.00



HandFinish

Memo

0.00

Hand Finishing

Wing walk as per Dwg D3267 and QSI 005 4.4 Spray Paint
Black 112594 Wing Walk: 113762

BR 10-03-3 ①

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10/03/03 ②

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Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/05 *[Signature]*
[Signature]
10-3-4

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Picklist Print

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Parent Item: D3267-041

Parent Item Name: Basket lid Assembly (Outside)

Start Date: 2/19/2010

Required Date: 2/25/2010

Comments: IPP Rev:C Removed -043 05-11-04 JLM
IPP Rev:D 08-09-10 revC as per dwg (ecn 08-524) DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2327-3		Manufactured	No			100	Each	51.0000	2.0000			



Spacer Bushing



SAD 10-02-23

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST	13	
----	----	--

44274	4	
-------	---	--

44365	9	
-------	---	--

Main Warehouse

WA	38	
----	----	--

55167	18	
-------	----	--

55917	20	
-------	----	--

D2506

Manufactured No

100

Each

8.0000

1.0000



Label Plate



SAD 10-02-23

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST	1	
----	---	--

44275	1	
-------	---	--

Main Warehouse

WA	7	
----	---	--

55700	7	
-------	---	--

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Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2581		Manufactured	No			100	Each	15.0000	2.0000			



Mounting Bracket



SAN

16-02-23

Warehouse Loc Qty Loc Code

Location

Main Warehouse

B55918

2

ST

12

46086

2

48428

1

51120

2

54862

7

Main Warehouse

WA

3

50872

1

51745

2

D3166-3

Manufactured No

100

Each

14.0000

1.0000



Basket Hoop



SAD

10-02-23

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

5

48429

5

Main Warehouse

WA

9.000014474

52058

1.4474E-05

54018

3

55697

6

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Shop Packet Print

Page 2

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Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304EX0.75-16F		Purchased	No			100	sf	1,072.652	8.2105			
Expanded Metal Flat SS												

SAD 10-02-23

Warehouse Loc Qty Loc Code
Location

Main Warehouse

MAT	1072.652006
111956	0.000017
112147	9.4736E-06
112949	32.58138
113205	0.0093
113497	0.1449
113555	773.4991
113904	266.4173

8.2106

M304TS0.750W.065 Purchased No



304 SQ Tube .75x.75x.065W

100 f 448.7902 32.2105

SAD 10-02-23

Warehouse Loc Qty Loc Code
Location

Main Warehouse

MAT	448.7901712
113082	0.00419
113245	0.00038421
113683	16.30855
113836	52.477047
113956	380

16 00
16.2105

Main Warehouse

WA	0.0000047
112398	0.0000047

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Shop Packet Print

Page 3

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QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X		D3267-041	BASKET LID ASSEMBLY (OUTSIDE)
	X	D3267-043	BASKET LID ASSEMBLY (INSIDE)
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
	1	D2989-1	STRUT
	1	D2989-2	STRUT
	1	D2989-3	STRUT
	1	D2989-4	STRUT
	2	D2989-5	STRUT
	2	D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
	2	D3182-1	HINGE
2	2	D3265-3	STRUT
1		D3266-7	STRUT
2		D3267-1	STRUT
	2	D3442-3	SHIM

#56347

RELEASED
06-09-04



NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
(D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236)
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT INDICATED AREA PER DART QSI 005 4.4.
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004

C	DRAWING UPDATED TO CURRENT STANDARDS. SHEET 3 ADDED. FRAME MATERIAL WALL THICKNESS WAS 0.060. D3267-1 DETAILED.	AJS	08.08.15
B	ADD SHIM UNDER HINGES	PH	05.06.08
A	NEW ISSUE	DS	04.02.02
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	PEL		
MFG. APPR.	PEL		
APPROVED	MM		
DE APPR.	MM	DRAWING NO. REV. C D3267 SHEET 1 OF 3 TITLE SCALE BASKET LID ASSEMBLY NTS	
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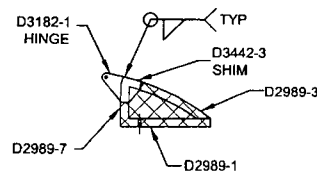
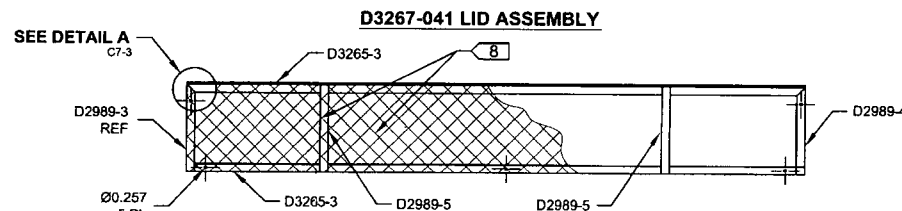
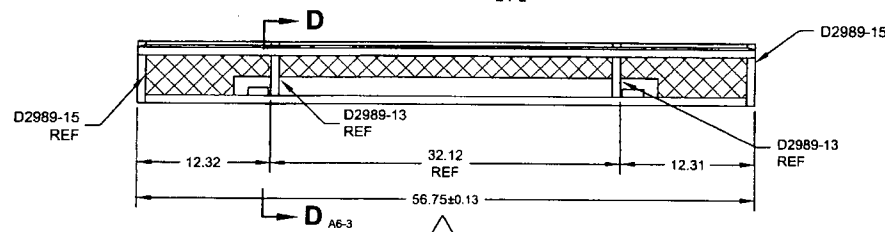
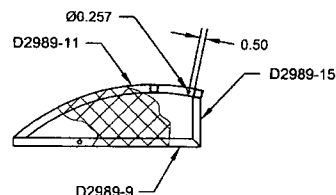
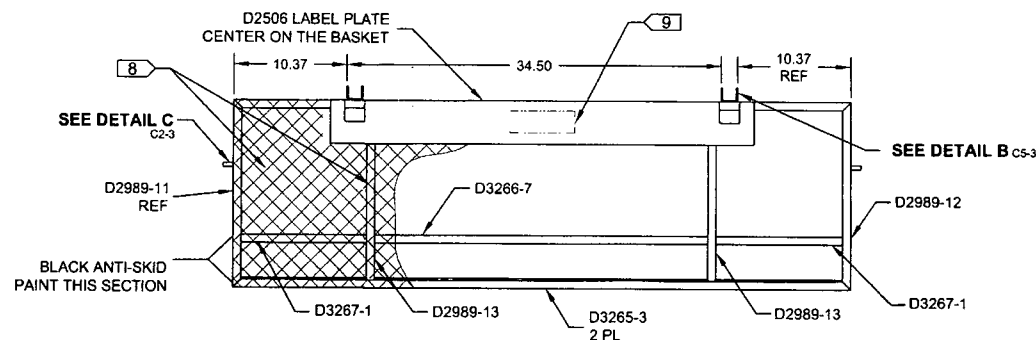
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NOTES:

- 1) MATERIAL: SEE SHEET 1
- 2) FINISH: SEE SHEET 1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) SKIN WITH EXPANDED STEEL MESH. TACK WELD MESH TO FRAME AT EVERY AVAILABLE LOCATION.
- 9) REMOVE 2" x 6" SECTION OF MESH FROM BEHIND LABEL PLATE

D3267-041 LID ASSEMBLY

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3267	2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
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08.09.04/18

#56347

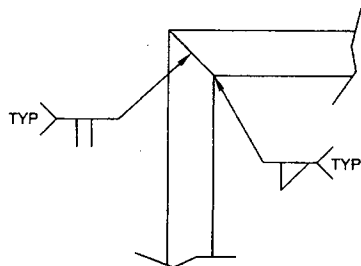
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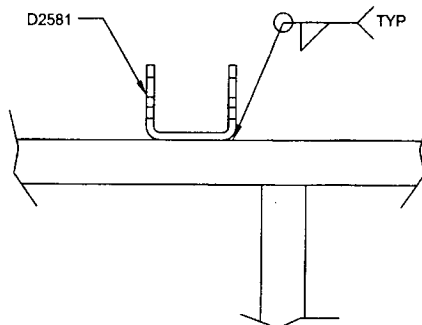
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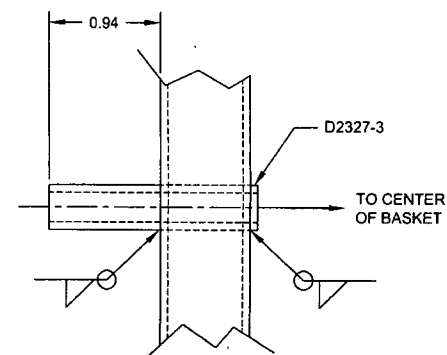
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DETAIL A B5-2
JOINT WELD DETAIL TYP
SCALE 2X

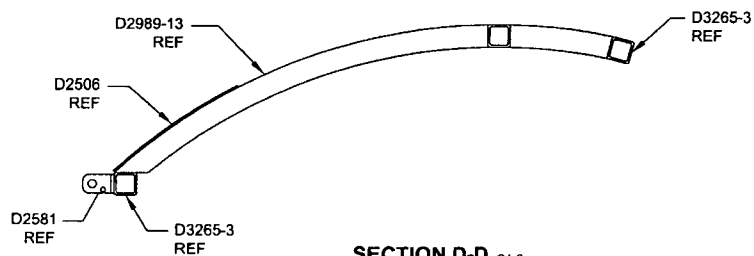


DETAIL B D2-2
2 PL
SCALE 2X

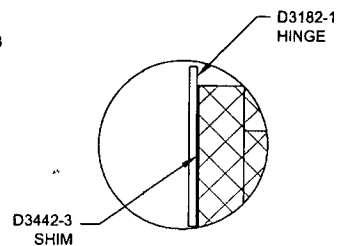


DETAIL C D5-2
SPACER INSTALLATION
SCALE 4X

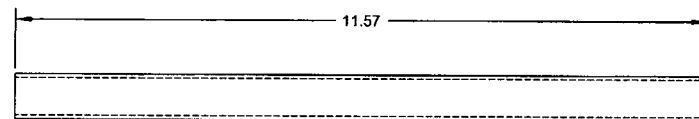
456347



SECTION D-D C4-2



DETAIL E B6-2
SCALE 2X
2 PL



D3267-1 STRUT
SCALE 2X

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08-07-01/14/15

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DRAWN	AUS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3267	3 OF 3
APPROVED		TITLE	SCALE
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